

Shaper Cutter Ø178 Z31

A12-210

To achieve an excellent surface finish - Ra less than 0.2 - , a roughing and finishing wheel is used. In function of the diameter of the tool 200 to 500 rpm are needed for the face grinding, which requires a fast A-Axis.



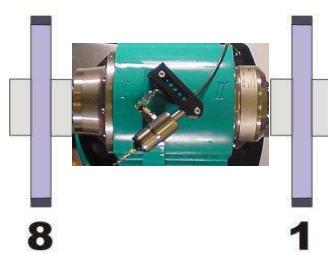
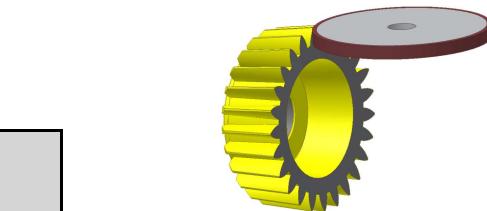
1. Cycletime for Resharpening

Tool specifications	
Diameter 178 mm, Z 31, Grinding Length 35 mm	
Material HSS	
Operations	Probe dress face roughing dress face finishing
Feed [mm/Min]	2000 150 180 150 200
Power [kW]	4 2 2 1
Cutting feed [m/s]	18 16 32 24
Used wheels	8 8 1 1
Grinding time [s]	23 112 499 112 131
Total cycle time	14 Min 37

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

8	1A1	Ø150	C120
1	1A1	Ø150	C180



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR, Dressing Unit, A-Rapid
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 bar
Software: Quinto 5

responsible engineer: OP,9.4.09

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